

Work Order ID 61475

Page 1

Thursday, August 26, 2010 2:39:38 PM

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Item Name: Replacement Float Skidtube

Stop



Start Date: 8/26/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3391	Rev H

100



0.00

DOCUMENT CONTROL

DC

Document Control

Memo

0.00

If D412-742-043 is a W/O on its own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



HandFinish

Hand Finishing

0.00

HandFinishing

0.00

27/01/10/08/31

1

0

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using

7/16" "T" Pins.

A/R Sikaflex-241/291 M115114Expiry date: 11/012-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.A/R Sikaflex-241/291 M115114Expiry date: 11/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.A/R LPS Procyon M114594

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Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

M 10 02 01 01

130



Packaging

Packaging

0.00

Ca 18/10/11

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location: *PPP*PPP Rev: *61/yr*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/03
MF 09-09-03

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Picklist Print

Page 1

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Work Order ID: 61475



4

Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev A 05.10.13 New Issue
IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
IPP Rev:C 07-05-28 As per Rev F JLM
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	1,769.000	24	24			

BOLT

Location	Loc Qty	Loc Code
ST303	500	
115438	500	
ST350	1269	
114108	14	
114416	12	
114523	2	
114941	241	X24 M1 10/08/31
115300	1000	

AN3C6A 	Purchased	No			110	Each	361.0000	12				
BOLT												

Location	Loc Qty	Loc Code
ST351	361	
111982	361	X12 M1 10/08/31

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 61475



Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C7A



Purchased

No

110

Each

174.0000

8

8



BOLT

Location	Loc Qty	Loc Code
ST351	174	
105906	4	
107376	4	
(113149)	121	
114382	45	

x8 jd 10/08/31

AN960C10L

NAS1149C0332

R

Purchased

No

110

Each

155.0000

44

44



washer

Location	Loc Qty	Loc Code
ST245	155	
107534	29	
109545	54	
111548	72	AA115000

x4 jd 10/08/31

D3391-021



Manufactured

No

pulled on

D3391-023
50621

110

356494

Each

0.0000

1

1



Fwd Tube Assembly



D3391-023



Mid Tube Assembly

Manufactured

No

pulled on

D3391-023
50621

110

356494

Each

1.0000

1

1



Location	Loc Qty	Loc Code
FP	1	
40522	1	B56621

x1 jd 10/08/31

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3391-025



Manufactured No

110

Each

1.0000

1

1



B56500 X1 Y1 10/08/13

Aft Tube Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP

1

48122

1

D3564-1



Manufactured No

110

Each

17.0000

1

1



Wearshoe

* ?

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG

2

33798

2

FP

3

51676

3

FP19

12

58823

12

D3564-3



Manufactured No

110

Each

16.0000

1

1



Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG

2

33764

2

FP19

14

55489

2

58825

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Parent Item: D412-742-043



Parent Item Name: Replacement Float Skidtube

Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

20.0000

1

1



Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	1	
34806	1	
FP19	2	
57525	1	
58709	1	
FP-19	17	
59157	6	
60868	11	

X1 M 10/03/31

D3566-1

Manufactured No

110

Each

27.0000

2



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	3	
60857	3	
FP015	24	
57715	2	
60202	12	
61215	10	

X2 M 10/03/21

D3566-5

Manufactured No

110

Each

29.0000

1



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	22	
60869	22	
FP015	7	
59158	7	

X1 M 10/03/31

W/O:		WORK ORDER CHANGES					
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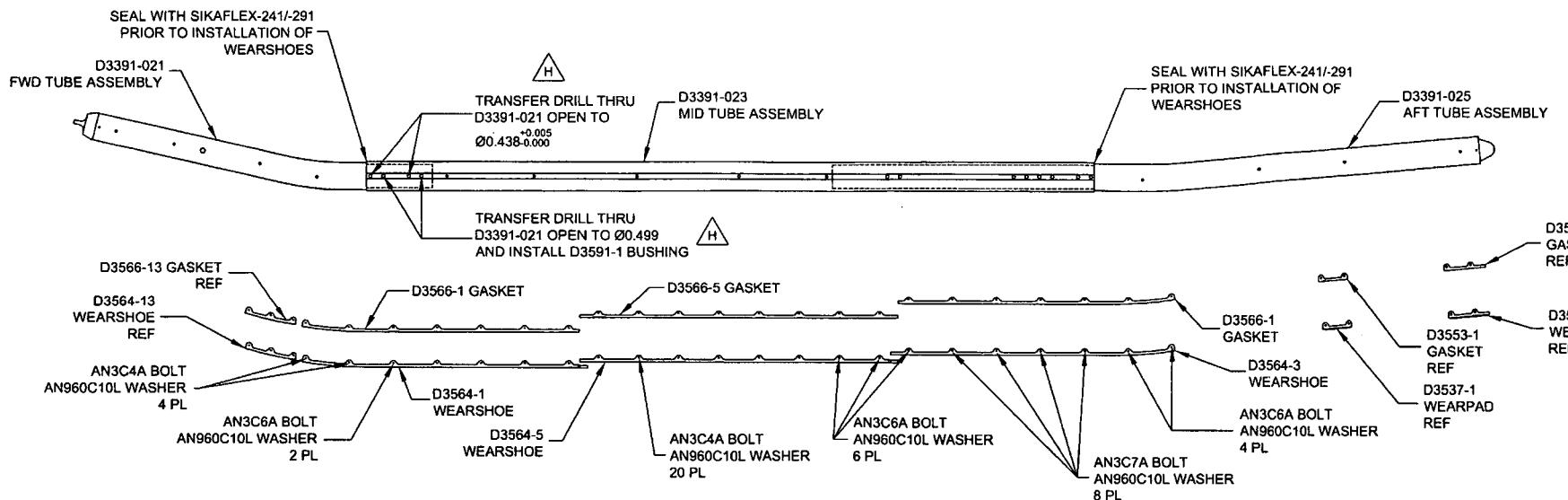
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WU 6475



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3568-1	GASKET
2	D3568-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DETACHED

RELEASED
08.08.20

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT MAY BE USED ONLY ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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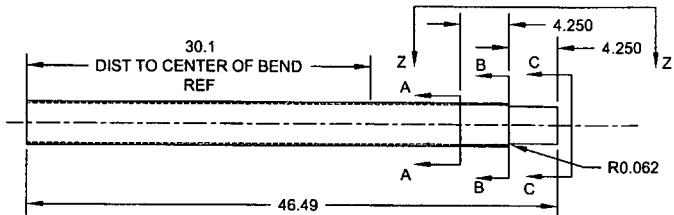
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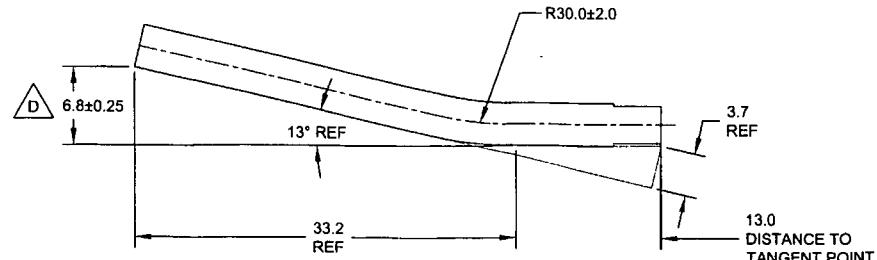
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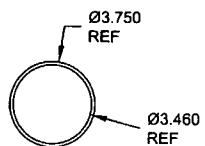
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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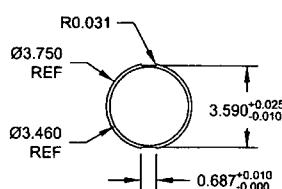


D3391-011-021 BENDING DETAIL
(MAKE FROM D3391-1)

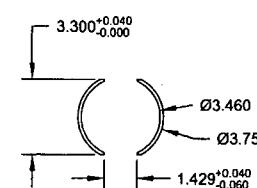
B



SECTION A-A
SCALE 2X

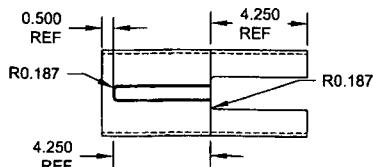


SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

A



VIEW Z-Z
SCALE 2X

W041175

DEO ATTACHED

RELEASED
08-09-05 AM

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AUS	PORT HADLOCK, WA
CHECKED		DRAWING NO.
		D3391
MFG. APPR.		REV. H
APPROVED		SHEET 3 OF 8
DE APPR.		TITLE
		412 FLOAT SKIDTUBE
DATE	08.08.20	SCALE
		NTS

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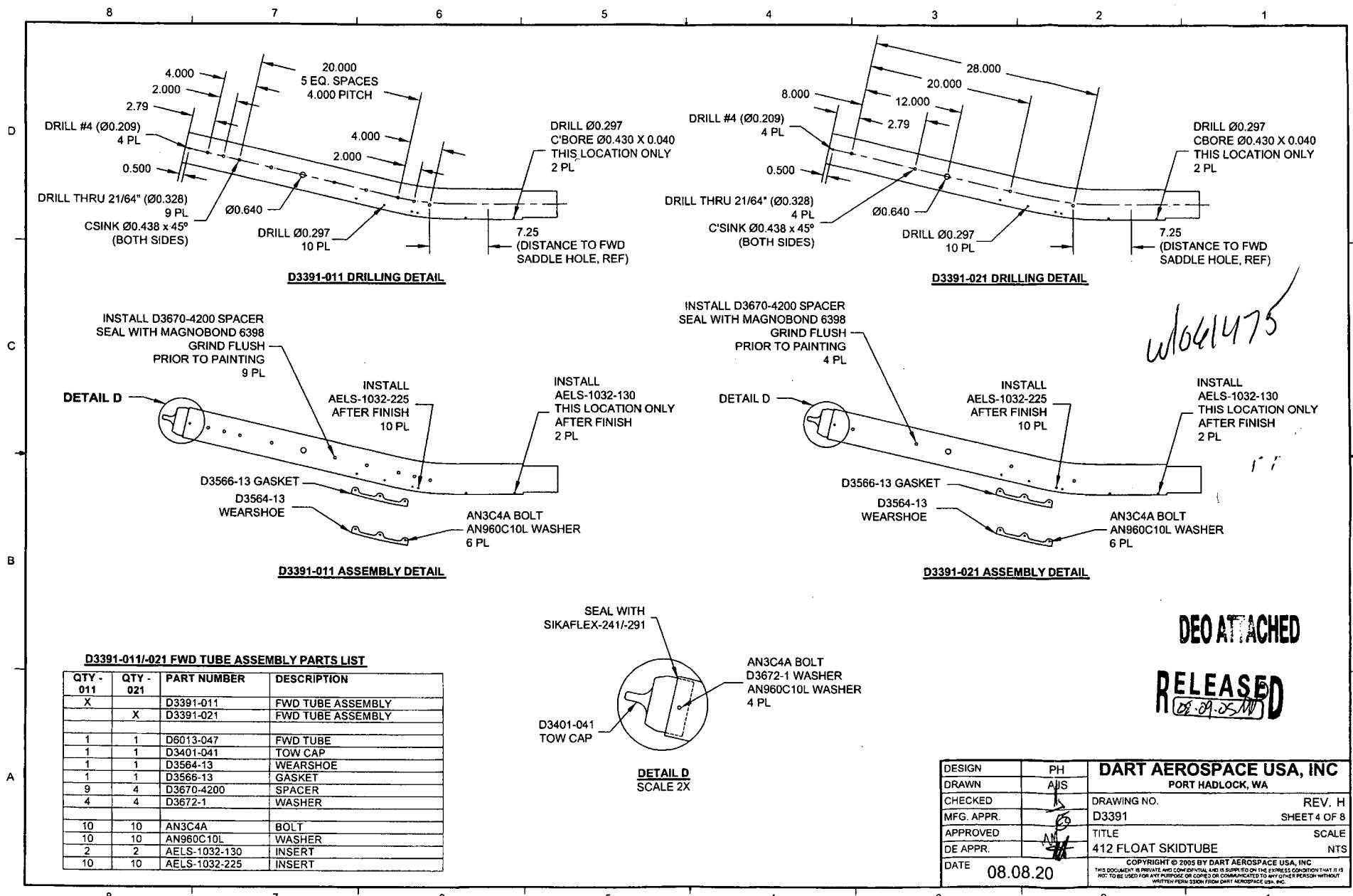
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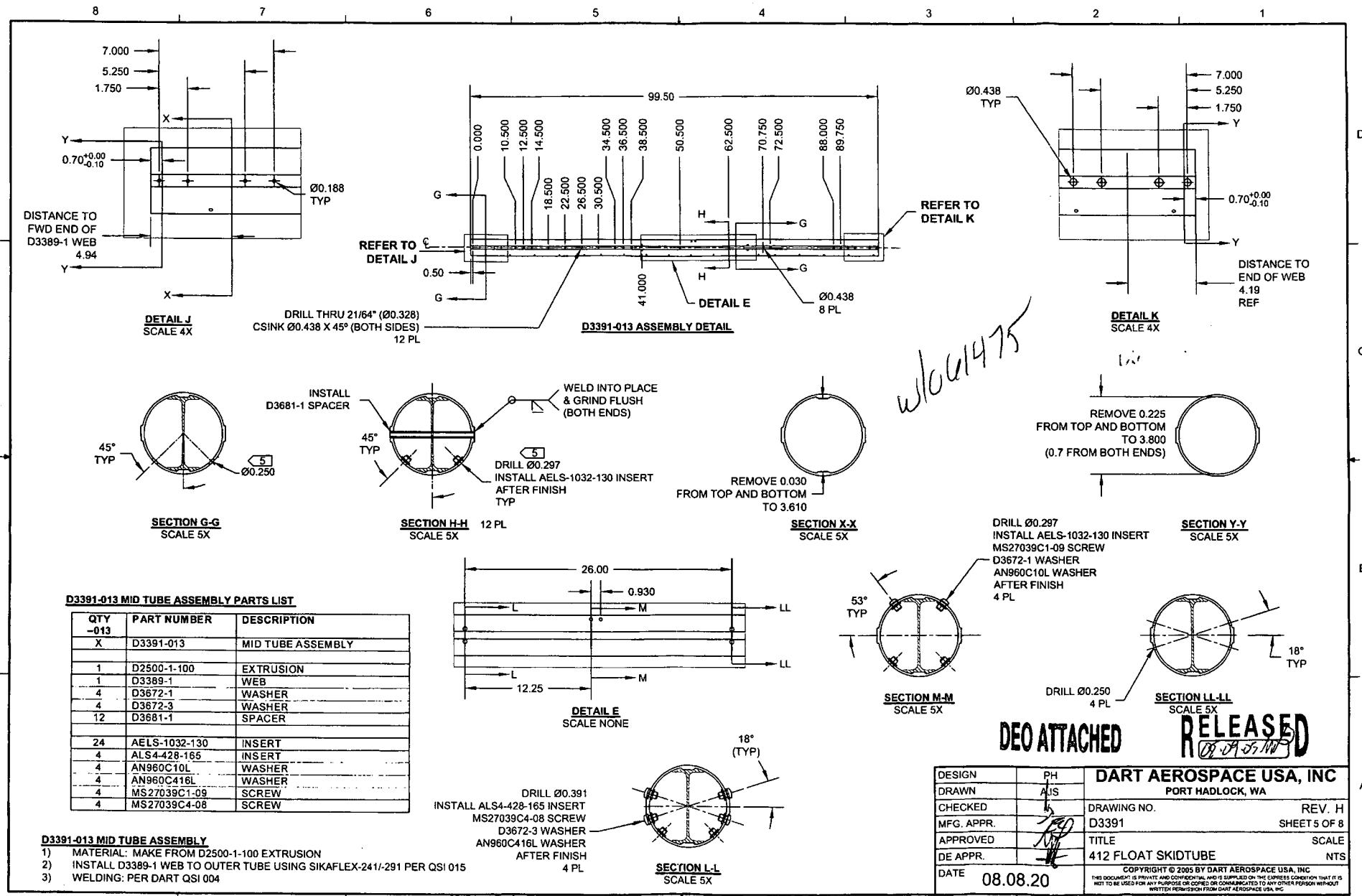
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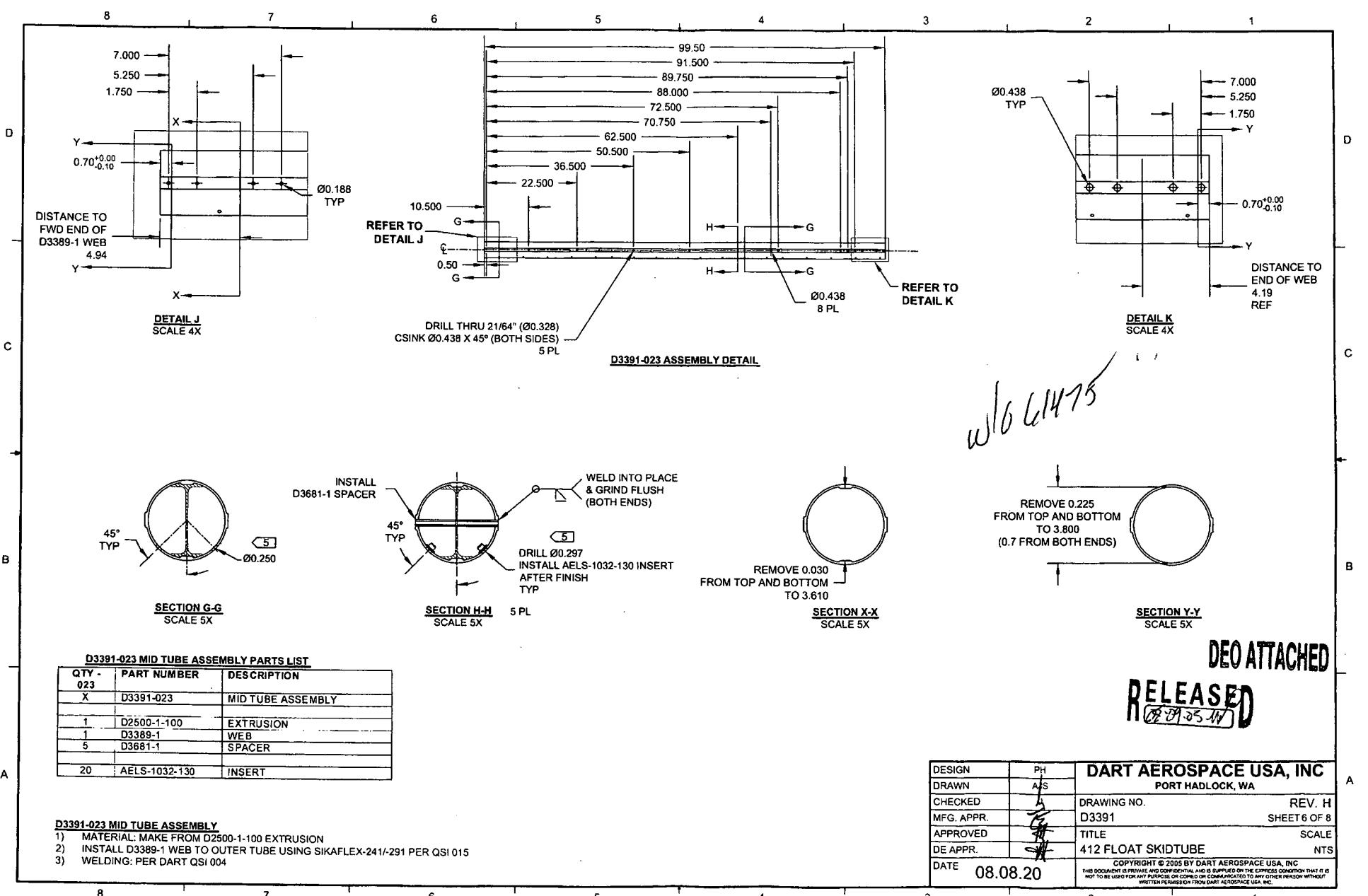
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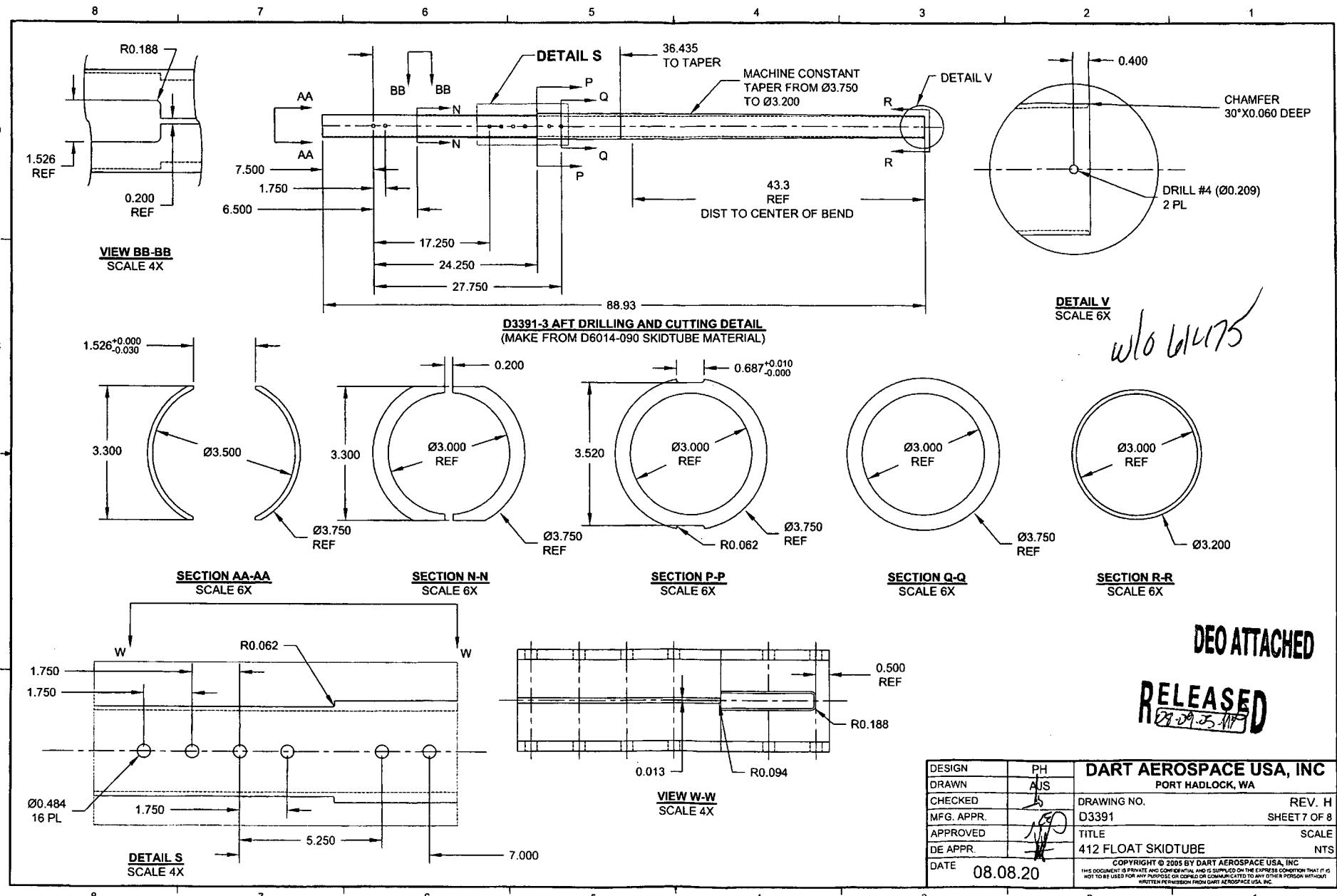
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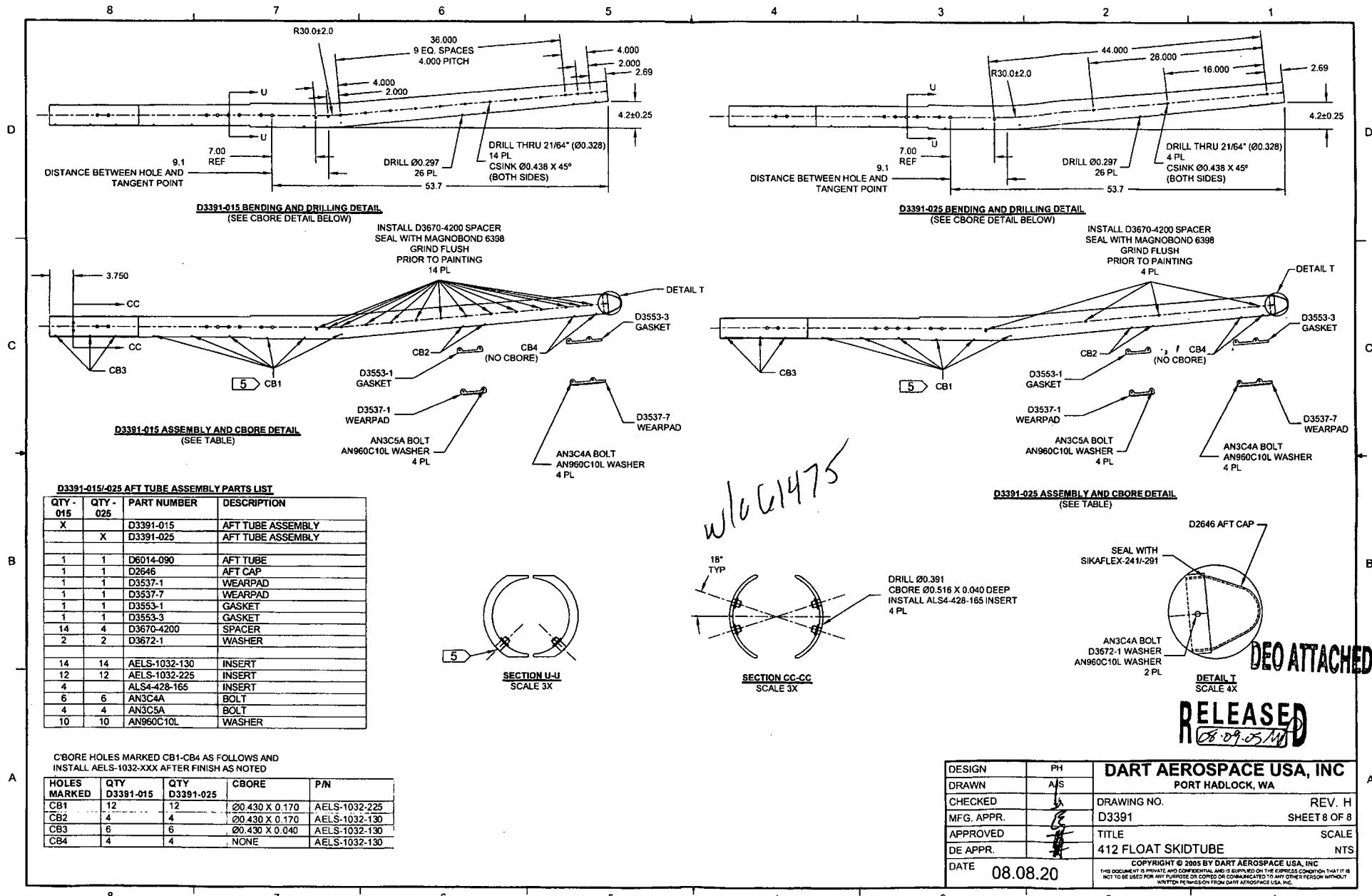
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>✓</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MD</i>	DE APPR. <i>✓</i>		
DATE 09.09.23	DATE 09.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30	DATE 09/09/30	

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

R E L E A S E D
2010-02-02

MP

W/0 6/17/15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries